

SPLIT

Dart Aerospace Ltd.

Date: Wednesday, 03/09/2008 10:35:13 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001	Dart Helicopters Services	Drawing Name	: SADDLE ASSEMBLY
Job Number	: 41767B		Part Number	: D2282043
Estimate Number	: 11180		Drawing Number	: D2282 REV E
P.O. Number	:		Project Number	: N/A
This Issue	: 03/09/2008	S.O. No. :	Drawing Revision	: E
Prsht Rev.	: NC		Material	:
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 30/10/2008
Previous Run	: 41173B		Qty:	100
Written By	:		Um:	Each
Checked & Approved By	: JUL 08.9.03			
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2281	Jack Saddle	 ✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2281 Saddle B41888 → 53x
			 50 8/08/10/09
2.0	D2282	Tube	 * Comment: Qty.: 2.0000 Each(s)/Unit Total : 200.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2282-7 tube B39817 → 47x
			 * 8/08/10/09
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	 Comment: LARGE FABRICATION RESOURCE 1 1-Weld as per D2282-043 Saddle Assembly A/R ER316L SS Filling Rod M108775 Dwg Rev: E
			 8/08/10/16
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- grind weld flush, take all welding marks out and deburr holes SAD 08/10/21 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE ASSEMBLY
Job Number: 41767B		Part Number: D2282043
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		 10/08/06
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		 S 08/06/06 (X100)
7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-tumble 		10/08/06
8.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		 S 08/06/06 (X100)
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Sylvie</u>		 50x SIP
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 08/11/06 HJ
Job Completion 		UMF 08-11-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

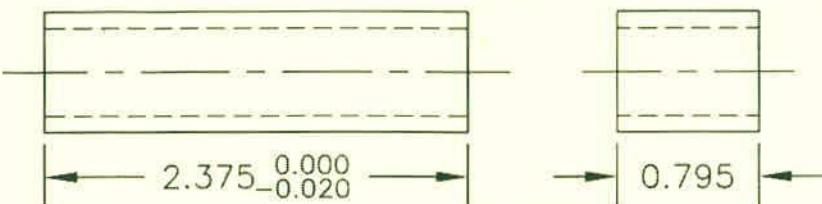
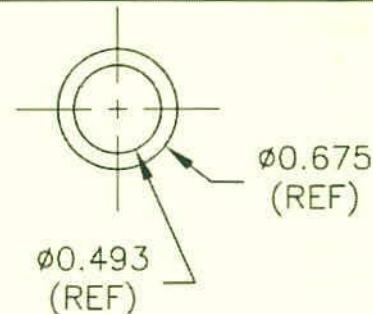
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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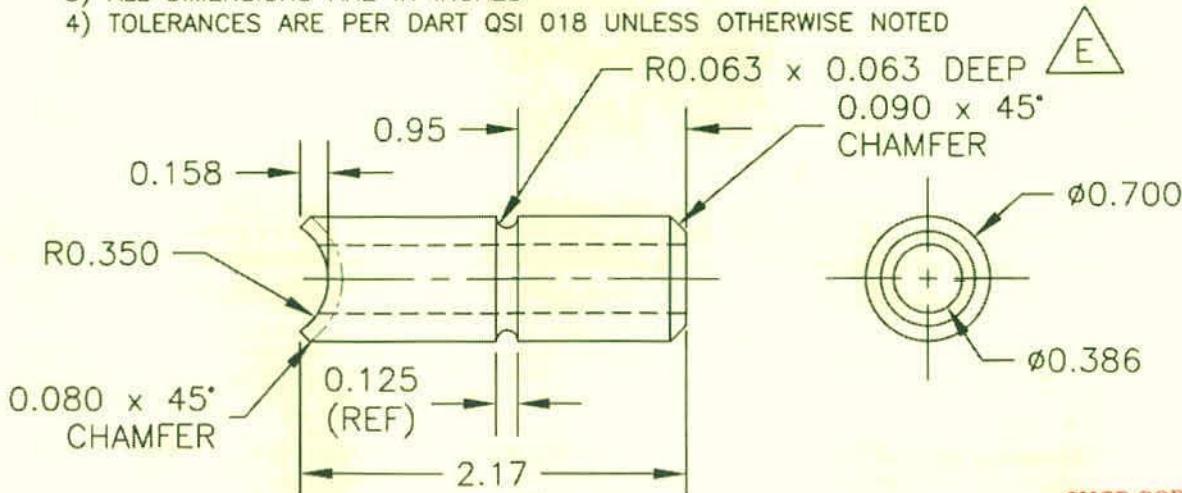
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>PZ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>100%</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

D2282-3D2282-7D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2282-5D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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ENGINEERING

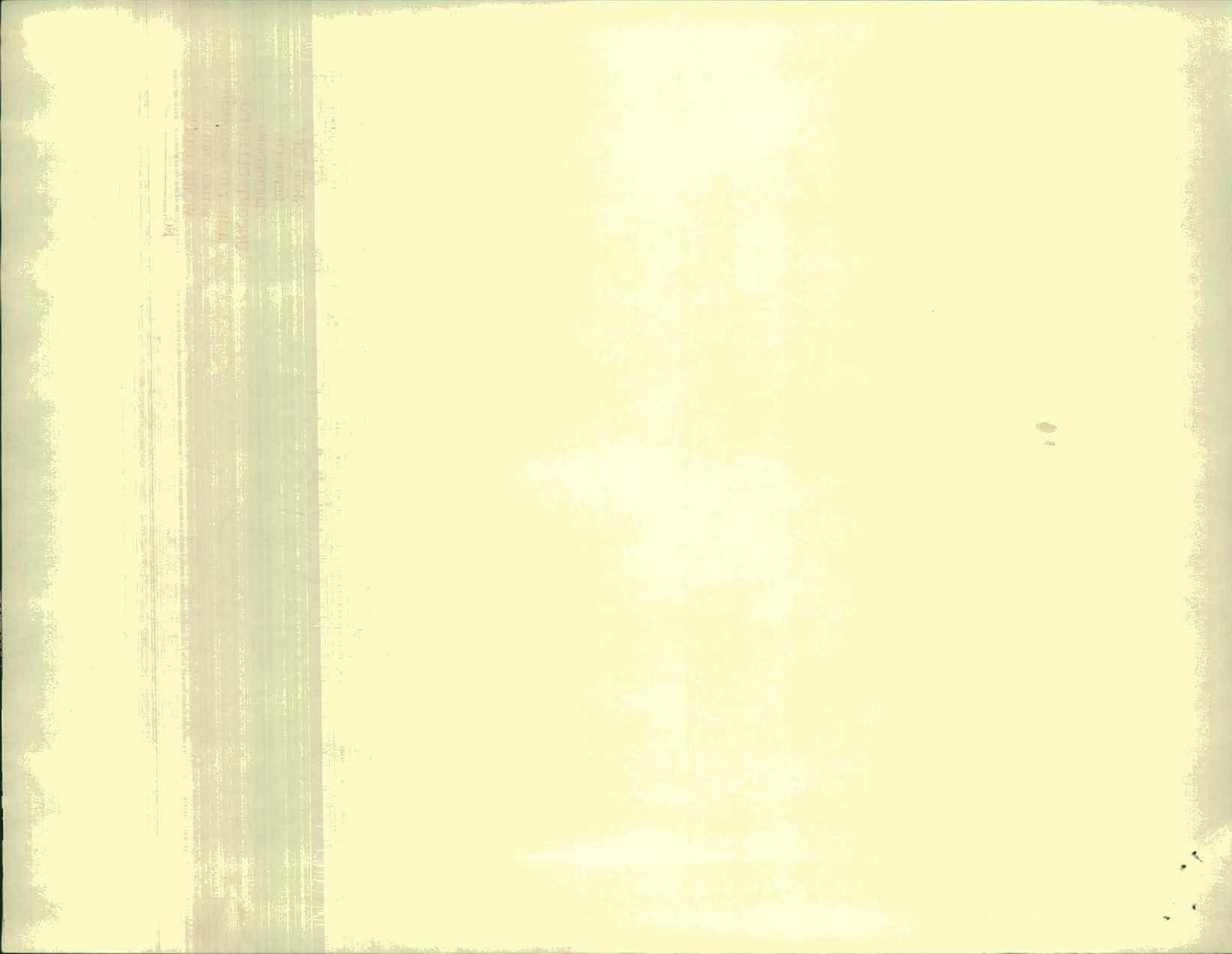
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SUBJECT TO AMENDMENT

WITHOUT NOTICE

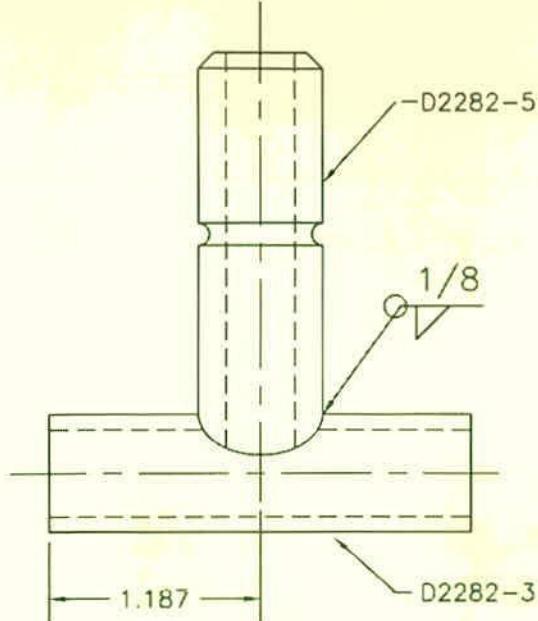
WORK ORDER

NO. 41767B

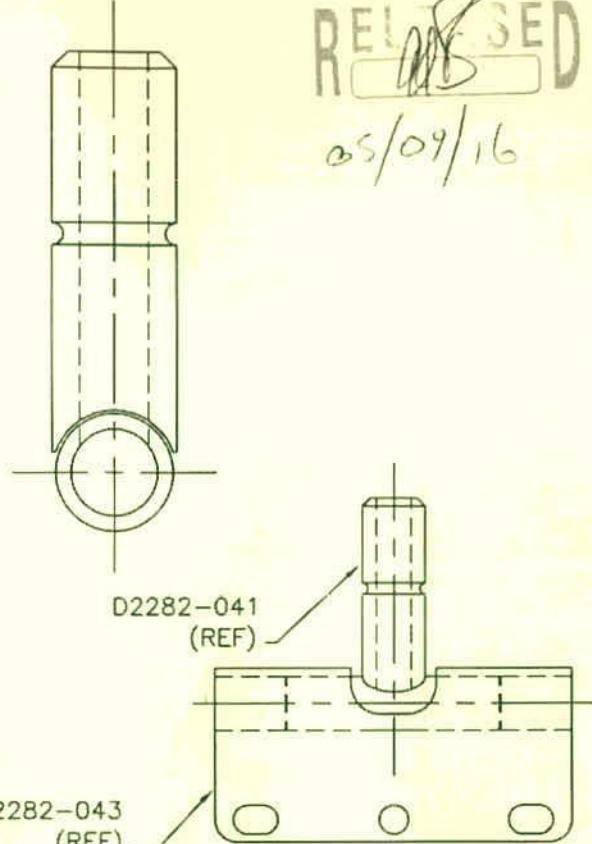


DART

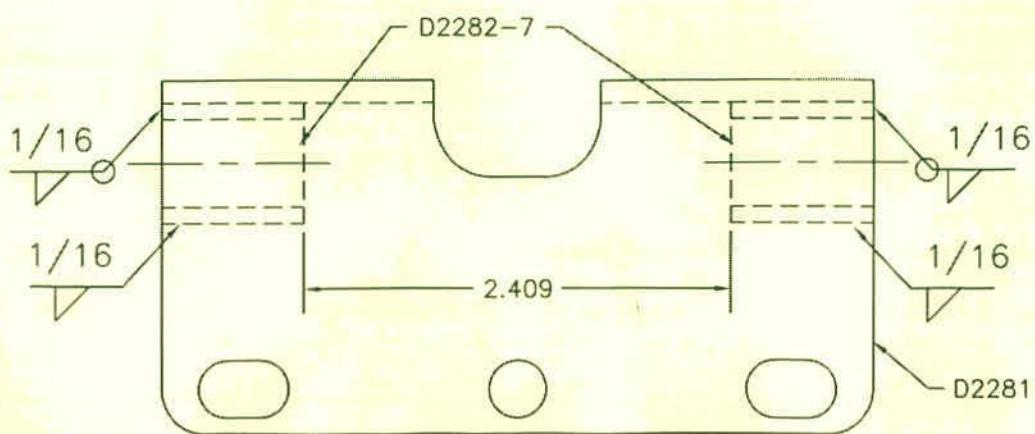
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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